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D350-636-023
Job Sheet 194172



Part No: D350-636-023

Job Qty: 1 pcs

Part Name: AS350/355 - Skidtubes - Standard w/ Heavy-Duty Wearplates - LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/26/19

Job Tracking No:

Due Date: 4/30/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: D4168-051 REV.C, IIN-D350-636 REV.K IPP REV.A 18.11.29 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Skidtubes - 1	1 pcs	4/30/19		0.00	5.25	Skidtubes - 1 - B			
							Skidtubes - 2 - B			
							Skidtubes - 3 - B			
							Skidtubes - 4 - B			
							Skidtubes - 5 - B			
							Skidtubes - 6 - B			
							Skidtubes - 7 - B			
120	QC 10	1 pcs	4/30/19		0.00	0.00	QC 10 - 10		MAY 03 2019	
							QC 10 - 18			
							QC 10 - 24	DAS		
							QC 10 - 43	24		
							QC 10 - 50	9-89		
							QC 10 - 58			
							QC 10 - 9			
130	QC 5	1 pcs	4/30/19		0.00	0.00	QC 5 - 10		MAY 03 2019	
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			

140 Handfinish - 1-1 Chemical-B4B	1 pcs	4/30/19	0.00 0.99	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R 19/05/06
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	4/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	JE
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	

160 Skidtubes - 2 - B4B	1 pcs	4/30/19	0.00 5.25	Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	4/30/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89 MAY 27 2019
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	DAS
				QC 5 - 3	24
				QC 5 - 43	9-89 MAY 27 2019
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	4/30/19	0.00 0.99	Handfinish - 2 - 1 - B4B	IL
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	4/30/19	0.00 0.91	Spray Paint - 1 - B4B	AL 19-6-16
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
				Spray Paint - MJ1 - B4B	
				Spray Paint - MJ2 - B4B	
				Spray Paint - MJ3 - B4B	
				Spray Paint - MJ4 - B4B	
210 QC 14	1 pcs	4/30/19	0.00 0.00	QC 14 - 15	AL 14-6-18
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
230 Handfinish - 4-1-Assembly-B4B	1 pcs	4/30/19	0.00 0.99	Handfinish - 4 - 1 - B4B	AL 14-6-20
				Handfinish - 4 - 10 -	

DAS
15
9-89

			B4B	
			Handfinish - 4 - 11 - B4B	
			Handfinish - 4 - 12 - B4B	
			Handfinish - 4 - 13 - B4B	
			Handfinish - 4 - 14 - B4B	
			Handfinish - 4 - 15 - B4B	
			Handfinish - 4 - 2 - B4B	
			Handfinish - 4 - 3 - B4B	
			Handfinish - 4 - 4 - B4B	
			Handfinish - 4 - 5 - B4B	
			Handfinish - 4 - 6 - B4B	
			Handfinish - 4 - 7 - B4B	
			Handfinish - 4 - 8 - B4B	
			Handfinish - 4 - 9 - B4B	
240 QC 5	1 pcs	4/30/19	0.00 0.00	QC 5 - 10
				QC 5 - 12
				QC 5 - 17
				QC 5 - 18
				QC 5 - 19
				QC 5 - 22
				QC 5 - 24
				QC 5 - 3
				QC 5 - 43
				QC 5 - 49
				QC 5 - 51
				QC 5 - 58
				QC 5 - 68
				QC 5 - 9
				QC 5 - 50
				QC 5 - 30
				QC 5 - 40
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 1 - 1 - B4B
				Packaging 1 - 2 - B4B
				Packaging 1 - 3 - B4B
				Packaging 1 - 4 - B4B
				Packaging 1 - 5 - B4B
				Packaging 1 - 6 - B4B
				Packaging 1 - 7 - B4B
				Packaging 1 - 8 - B4B
				Packaging 1 - 9 - B4B
				Packaging 1 - 10 - B4B
				Packaging 1 - 11 - B4B
				Packaging 1 - 12 - B4B
				Packaging 1 - 13 - B4B
				Packaging 1 - 14 - B4B
				Packaging 1 - 15 - B4B
				Packaging 1 - 16 - B4B
				Packaging 1 - 17 - B4B
				Packaging 1 - 18 - B4B
				Packaging 1 - 19 - B4B
				Packaging 1 - 20 - B4B
				Packaging 1 - 21 - B4B
				Packaging 1 - 22 - B4B
				Packaging 1 - 23 - B4B
				Packaging 1 - 24 - B4B

				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	4/30/19	0.00 0.00	QC 4 - 28	DAS 75 9-89
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	JUL 1 1 2019
270 Packaging 3-1 - Stock - B4B	1 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS 75 9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	JUL 1 1 2019
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	4/30/19	0.00 0.00	DC - 1 - B4B	DAS 21 9-89
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	4/30/19	0.00 0.00	QC 21 - FG - 21	JUL 1 1 2019
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg

Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168 sheet 4 (D4168-5 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section DE-DE. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "DA" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail DA to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 136909 9- Grind welds flush as per Dwg D4168

120 - (QC10- Inspect visual per QSI004- ground welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - 1-Open up holes using hole saw of Detail DB and ground handling section EN-EN to 0.625" (total of 8 holes per side) as per dwg D4168. Open wearplate holes to size as per dwg (4 holes per sides) , section EP-EP 4-Chamfer holes of Detail DB, ground handling section AL-AL per dwg D4168 (welding instructions on sheet 8) 5-Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 174342 exp. date: 08/12/19 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet) A/R Aluminum Rod batch: 139011 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section EN-EN 12- C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Deburr holes, ensure tube is free of all scratches before sending to paint. *****

170 - QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***

190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: 5189640 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5188693

210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5163437 EXP DATE: 14-12-2 5-Coat all exposed fasteners with "LPS Procyon" batch: M133696

240 - (QC5- Inspect part completeness to step on W/O)

250 - (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A

260 - QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****

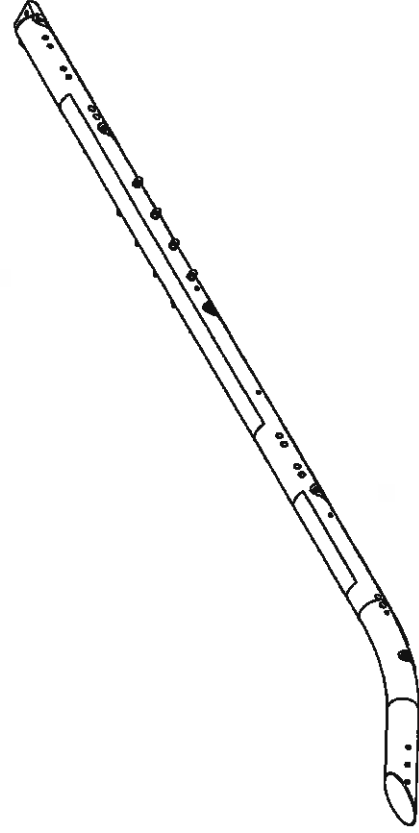
270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-636-023 Location :FG071

275 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-023 CHG 001

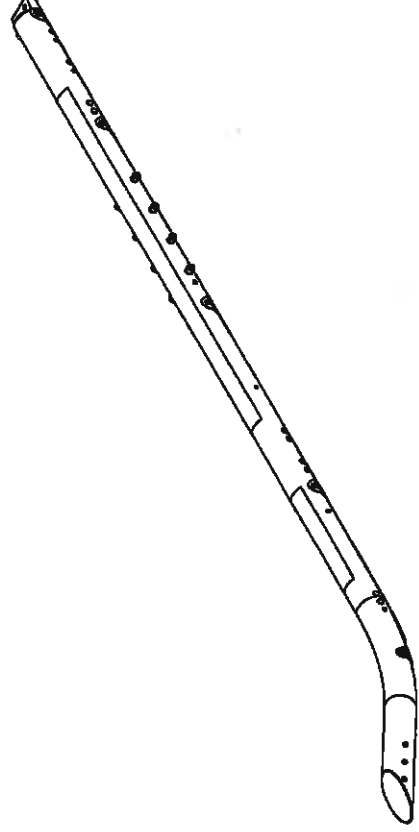
280 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	010453
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5166439
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5150291
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5180535
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5182366
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5167517
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5171235
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5176396
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167090
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5188181
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5179190
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5175779
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	180796
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	X 5191506
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5099569
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5181737
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167202
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5158079
NAS1149C0332R	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5138100
NAS1149C0363R	Washer	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017
NAS1149C0832R	Washer	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5083559
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	
	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5162134
	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5160968
	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5159549
	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5167203
	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	6	0
	D2744	1	16	0
	D2739	1	8	0
160-Skidtubes - 2 - B4B	D2743	8	135	0
	ALS4-1032-225	4	1,681	0
	AN3C34A	1	12	0
230-Handfinish - 4-1-Assembly-B4B	AN3C36A	4	351	0
	AN3C6A	4	317	0
	AN6C44A	4	132	0
	AN8C35A	1	62	0
	D2745	8	168	0
	D3488-3	1	3	0
	D3631-1	8	197	0
	D3873-1	7	76	0
	D4154-041	1	5	0
	D4170-1	4	38	0
	D4171-1	1	8	0
	MS21043-3	5	1,018	0
	MS21043-6	4	154	0
	MS21083C8	1	210	0
	NAS1149C0332R	4	5,640	0
	NAS1149C0363R	9	437	0
	NAS1149C0832R	1	340	0
	NAS1515H3L	4	358	0
	AN3C37A	1	52	0
	AN8C21A	2	85	0
	D2741	1	63	0
	MS21083C8	2	210	0
	NAS1149D0863J	2	465	0
250-Packaging 1-1 - Pick Kit - B4B				



D4168-043 350 SKIDTUBE ASSEMBLY.LH



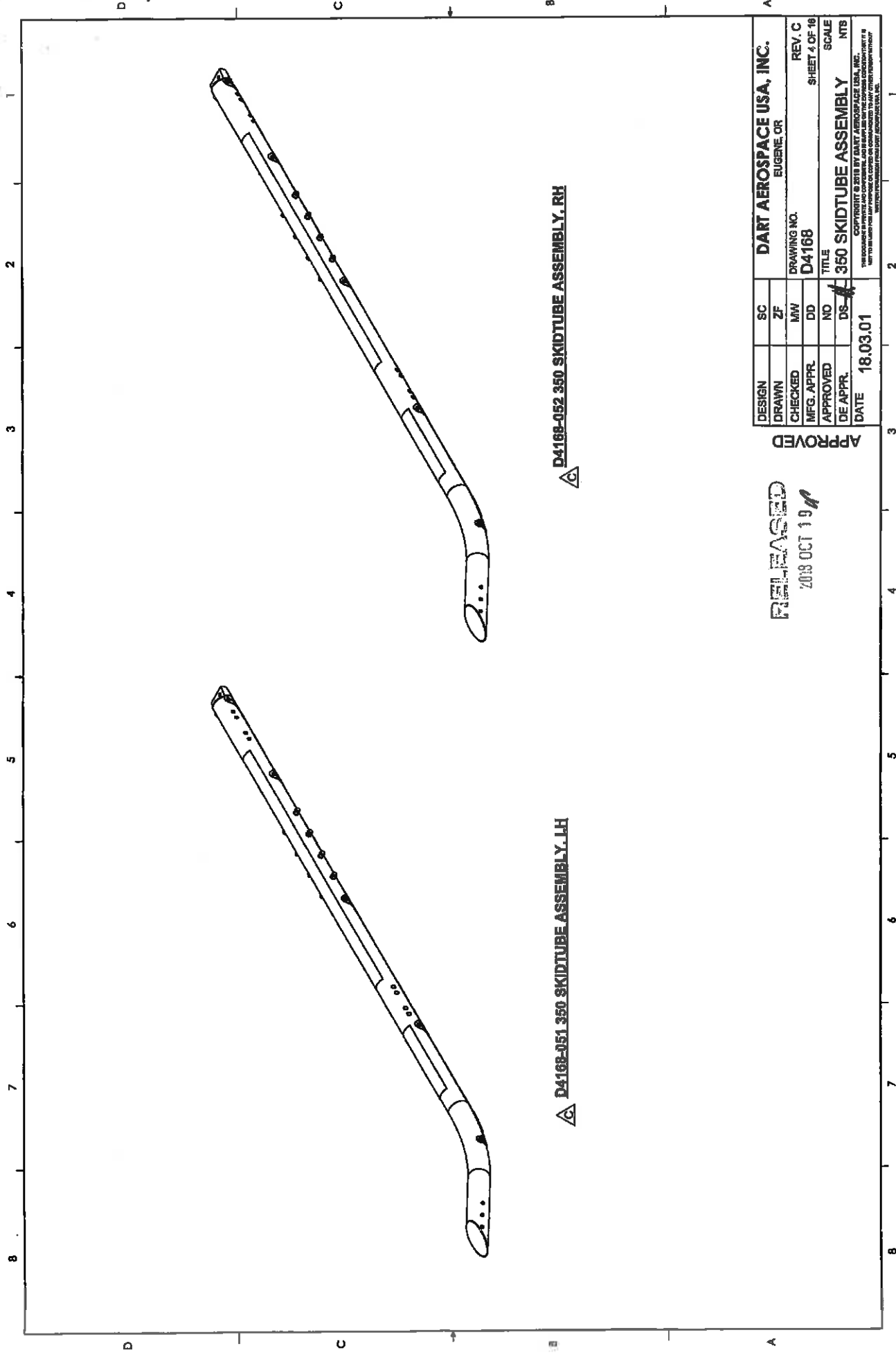
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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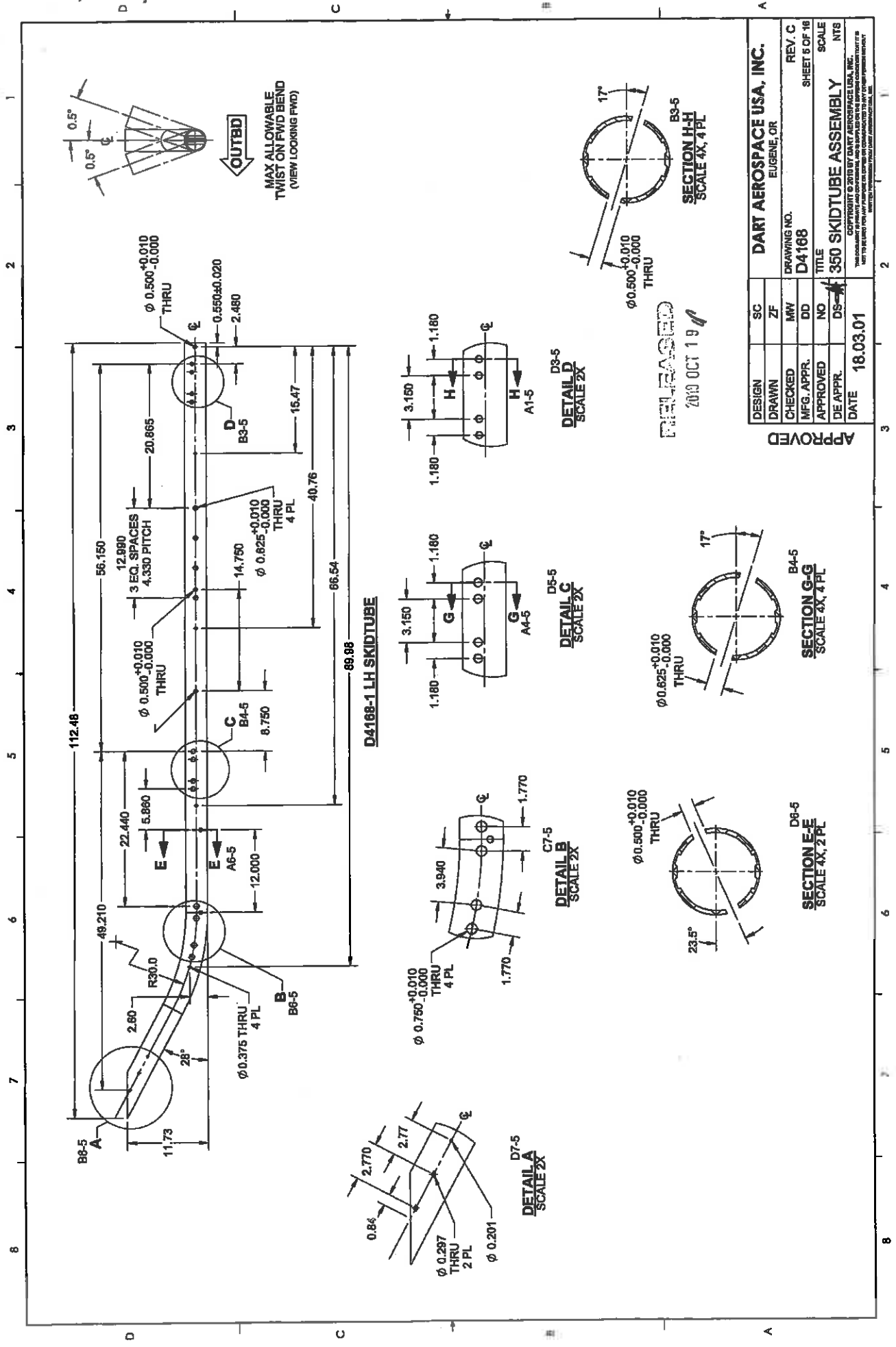
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CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR.	DS	DATE	18.03.01



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2018 OCT 19

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DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 4 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	COMPONENT IS RUN BY DART AEROSPACE USA, INC.	
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DRAWN			MMV	
CHECKED			DD	
MFG. APPR.			DD	
APPROVED			NO	
DATE	18.03.01		DATE	

APPROVED

350 SKIDTUBE ASSEMBLY

NTS

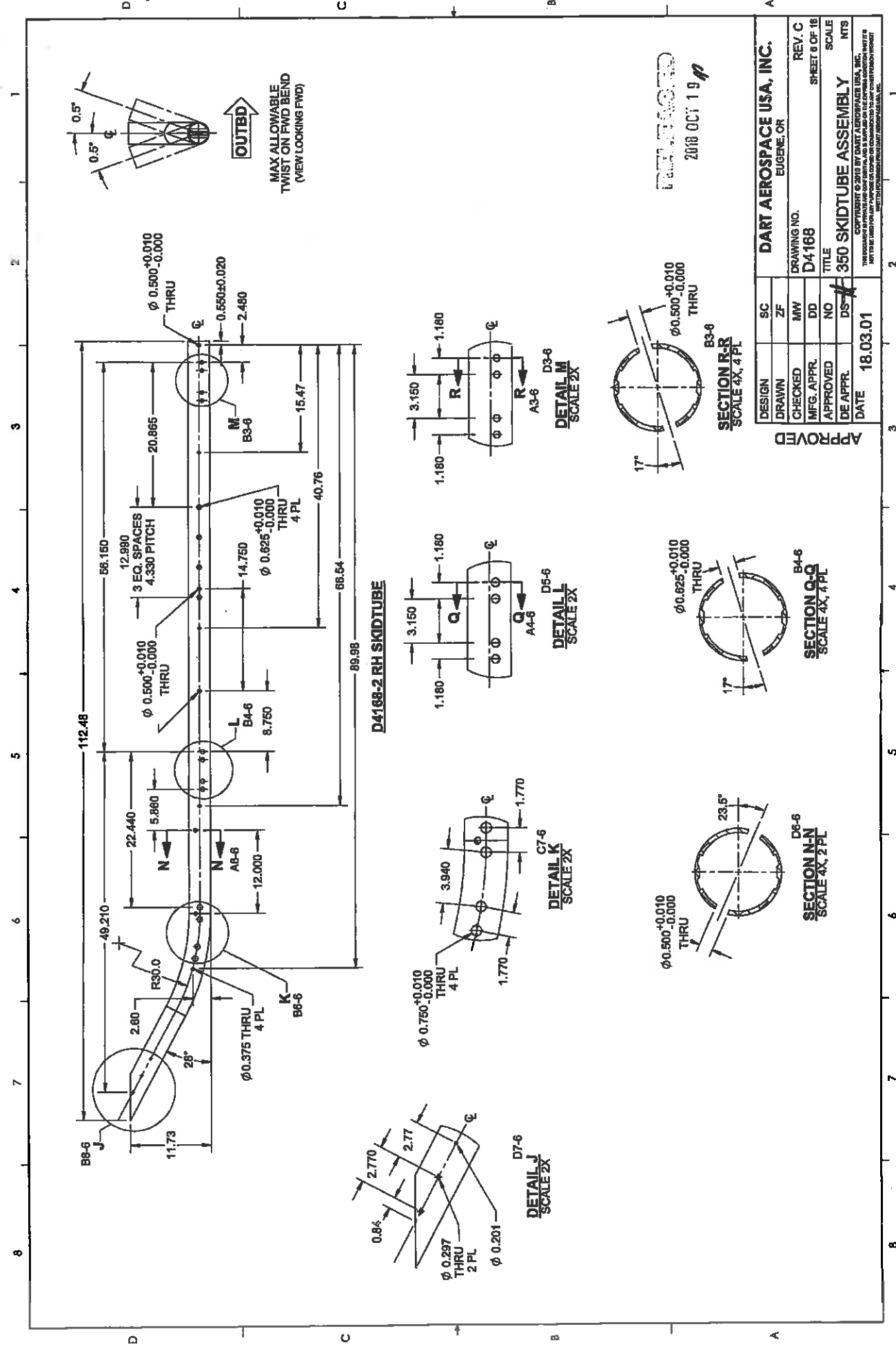
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SHEET 6 OF 16

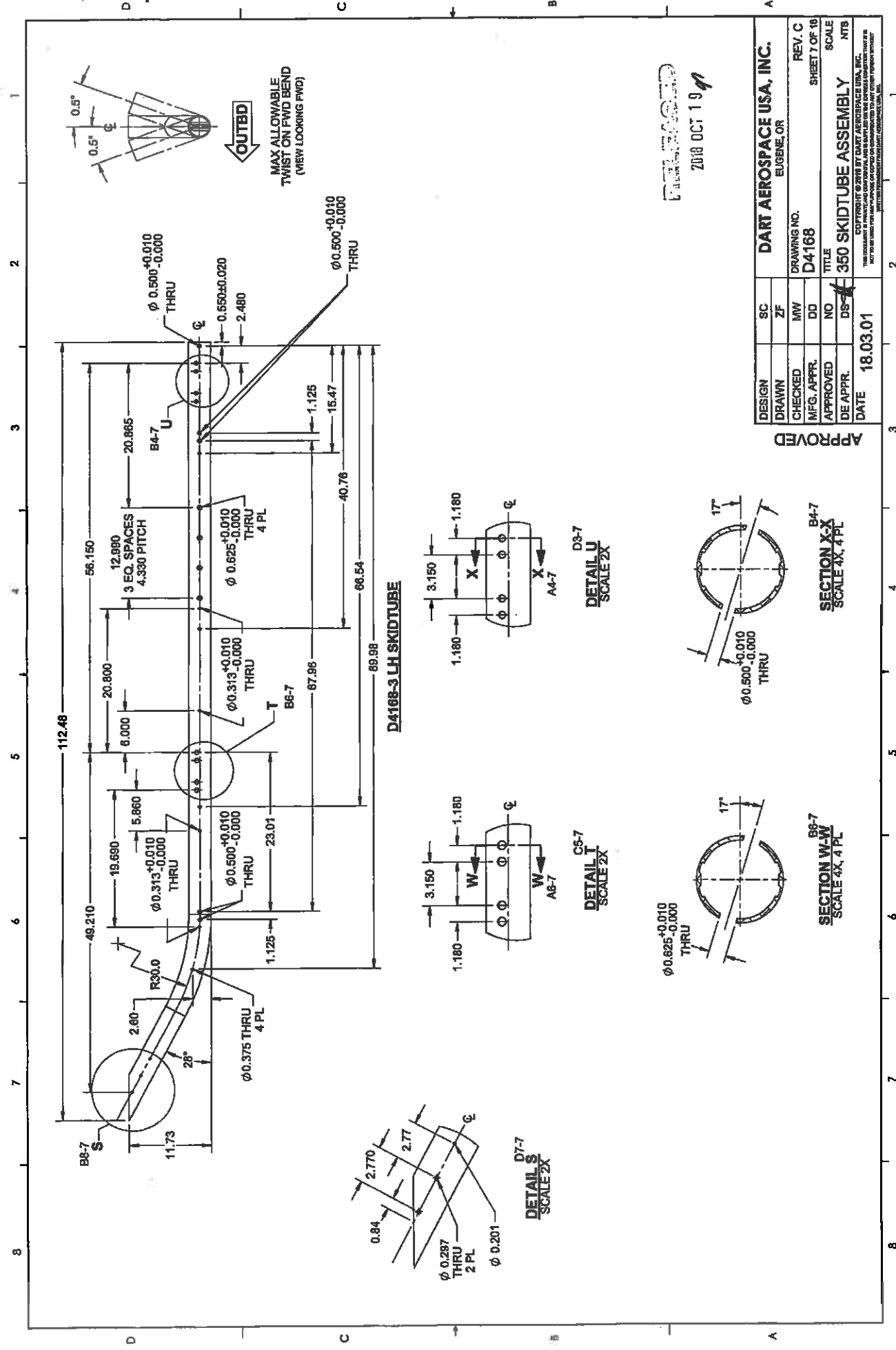
REV. C

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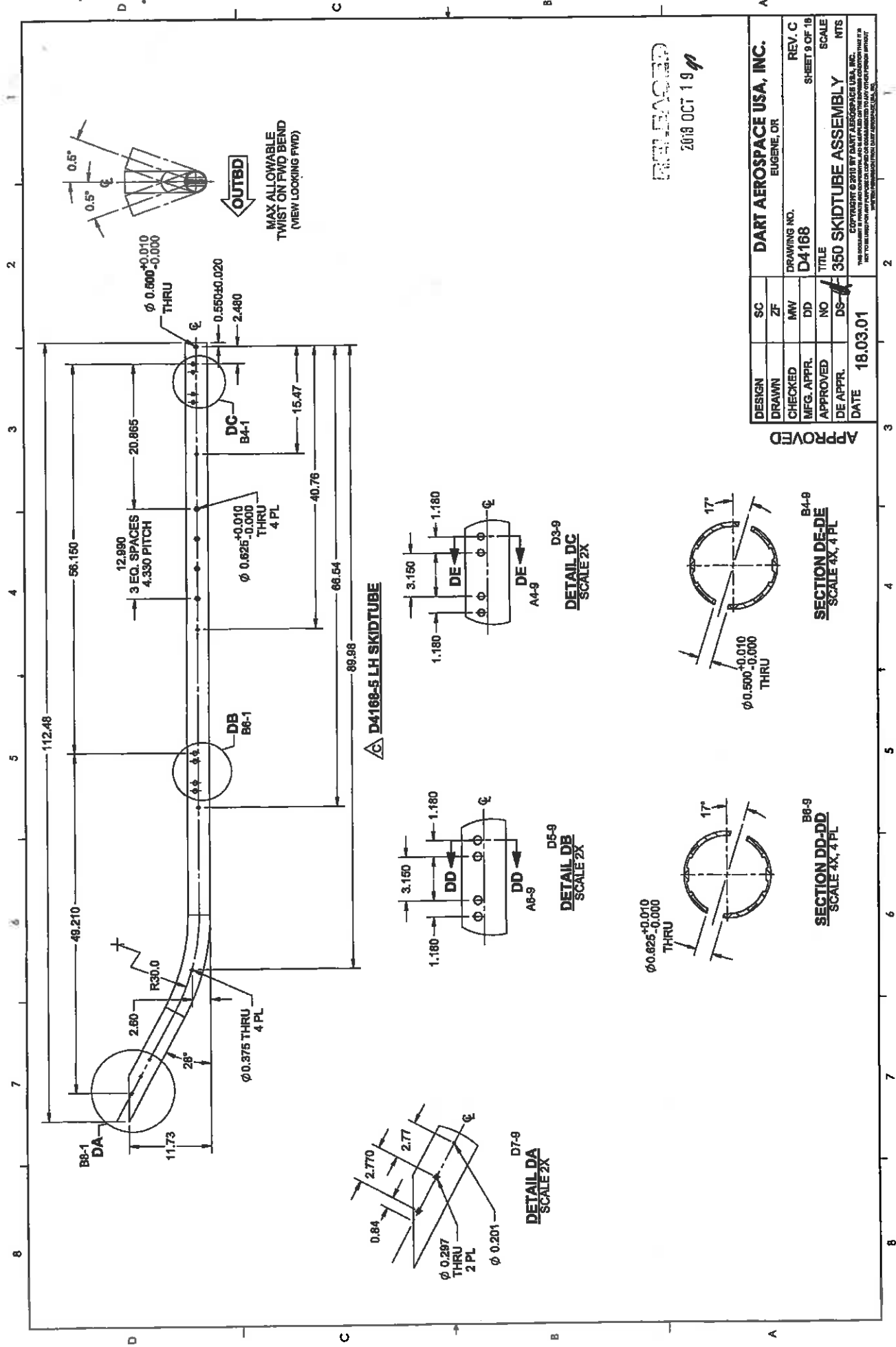


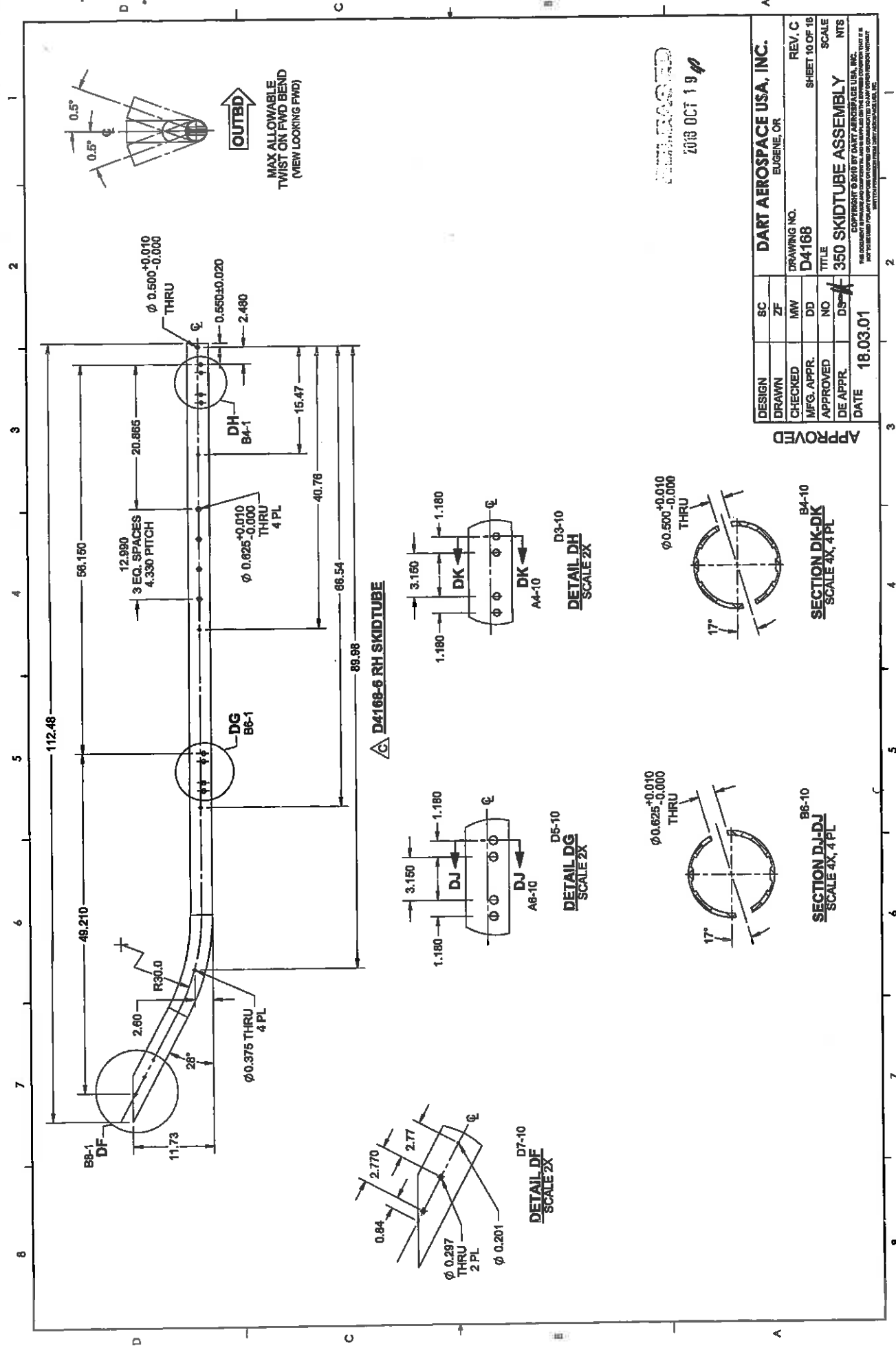
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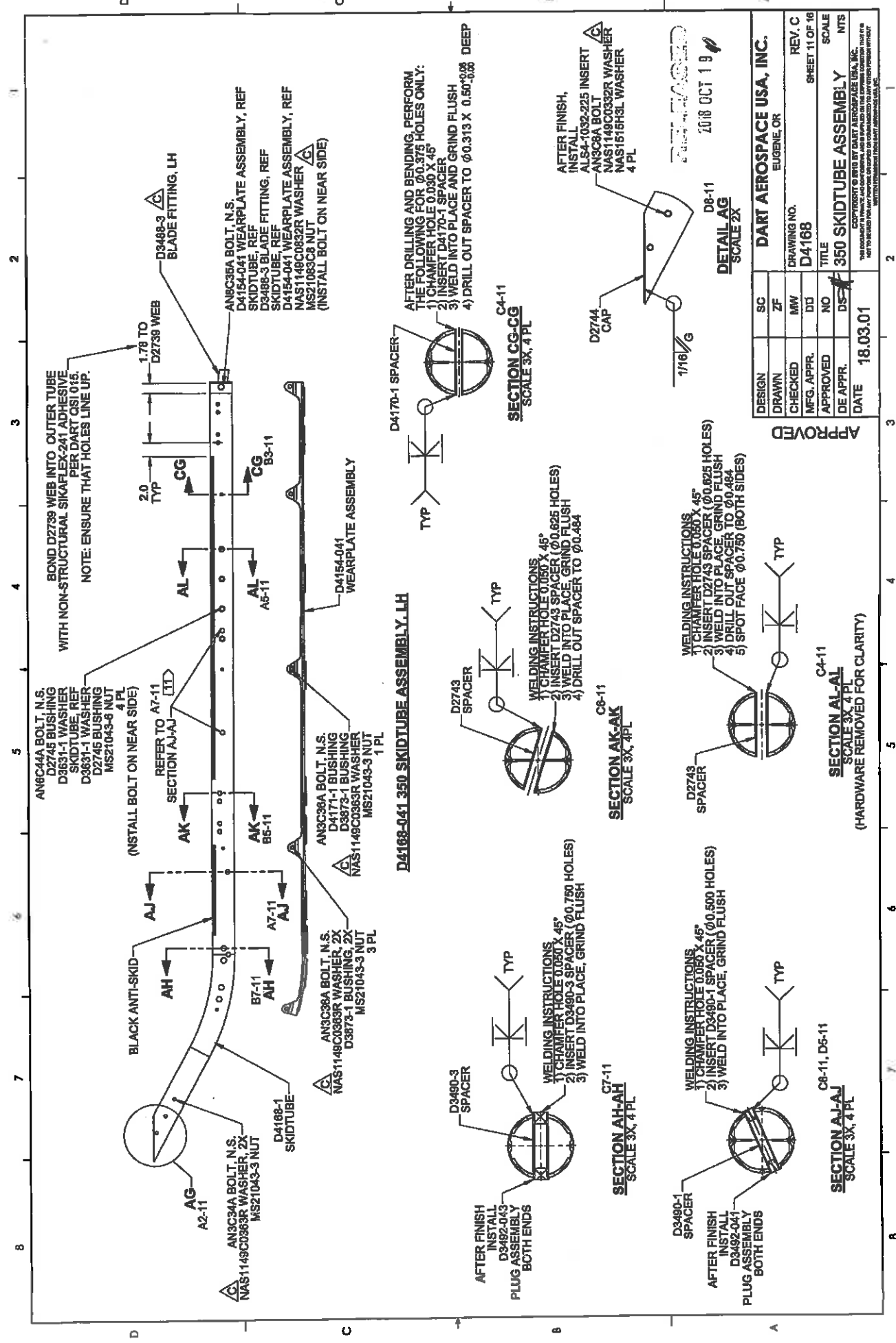
APPROVED

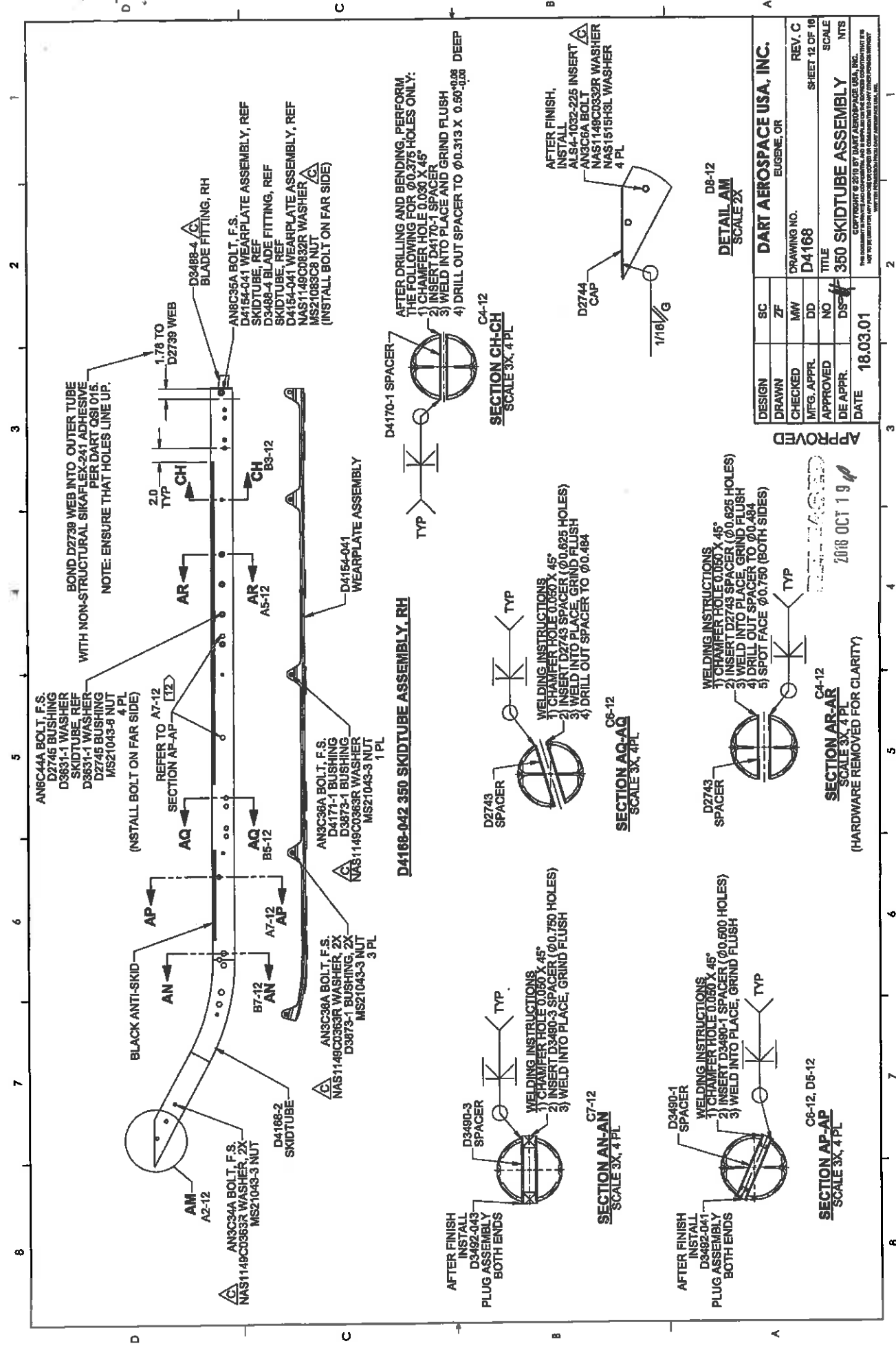
DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D4168 REV. C SHEET 7 OF 18 SCALE 360 SKIDTUBE ASSEMBLY NT8 COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. ALL RIGHTS RESERVED. THIS DRAWING IS UNCLASSIFIED TO THE EXTENT PERMITTED BY LAW. THIS DRAWING IS YOUR PROPERTY AND IS TO BE RETURNED TO THE ISSUING ORGANIZATION.
DRAWN	ZF	
CHECKED	MW	
MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS	TITLE
DATE		18.03.01

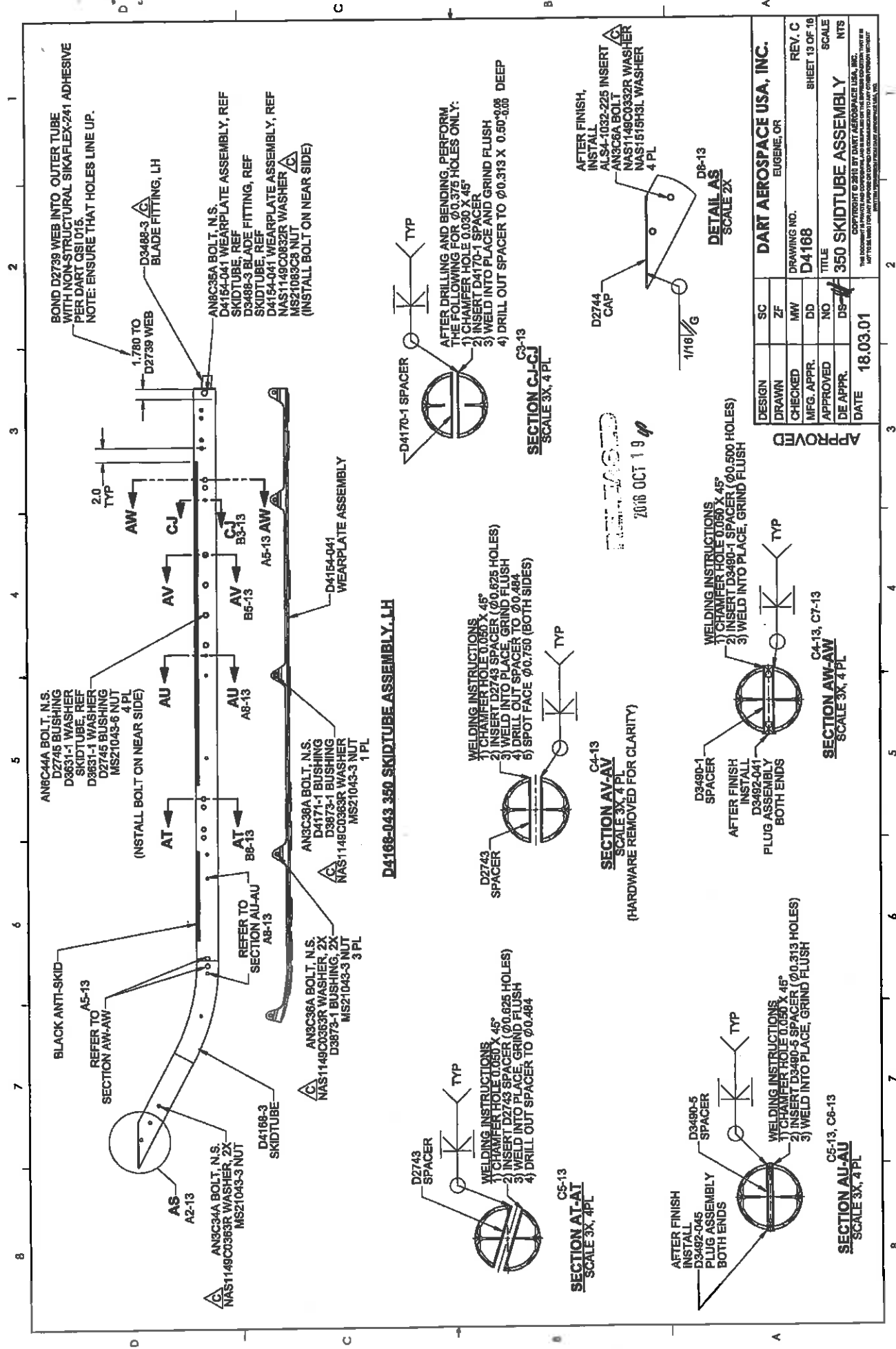


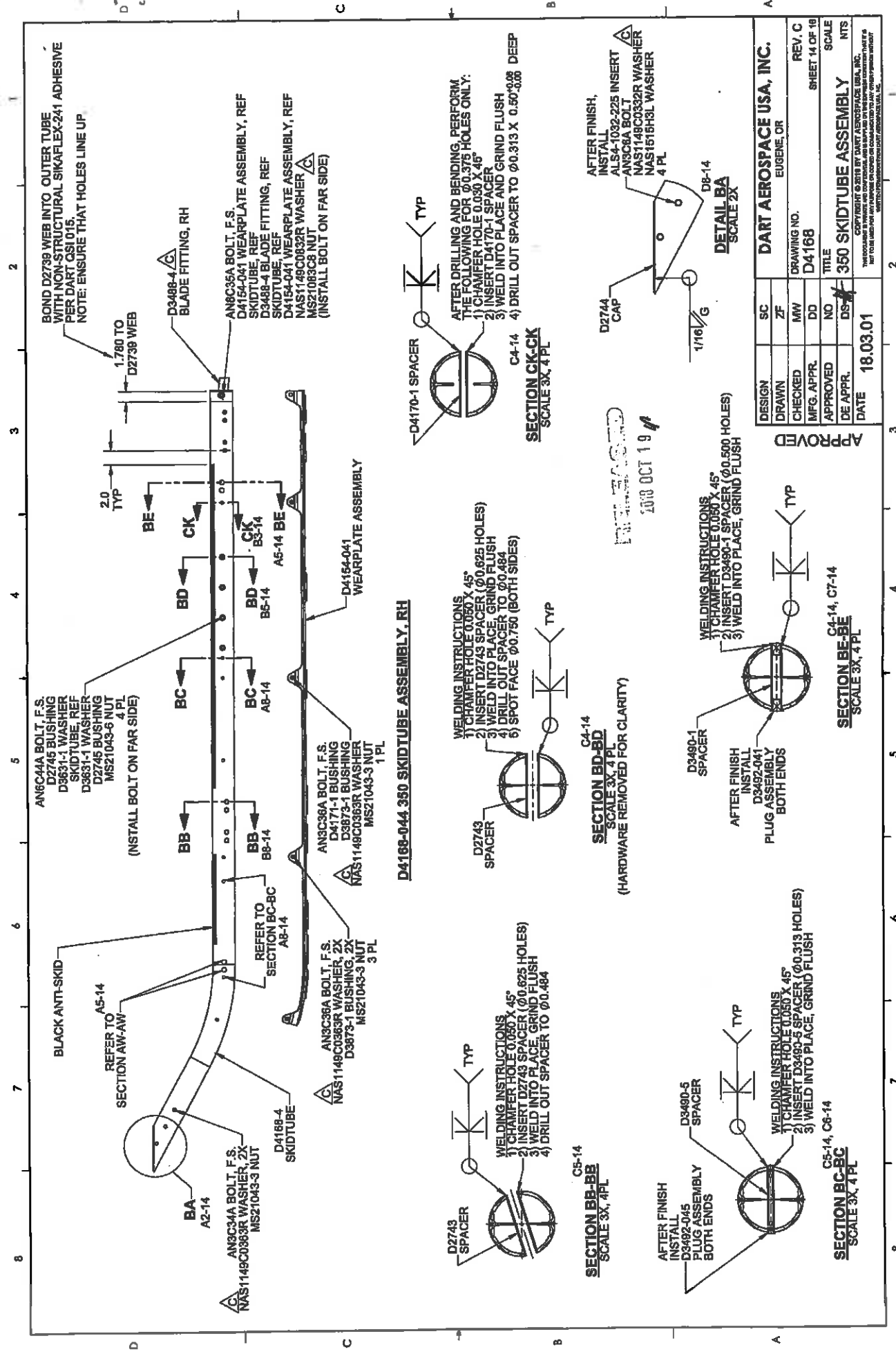


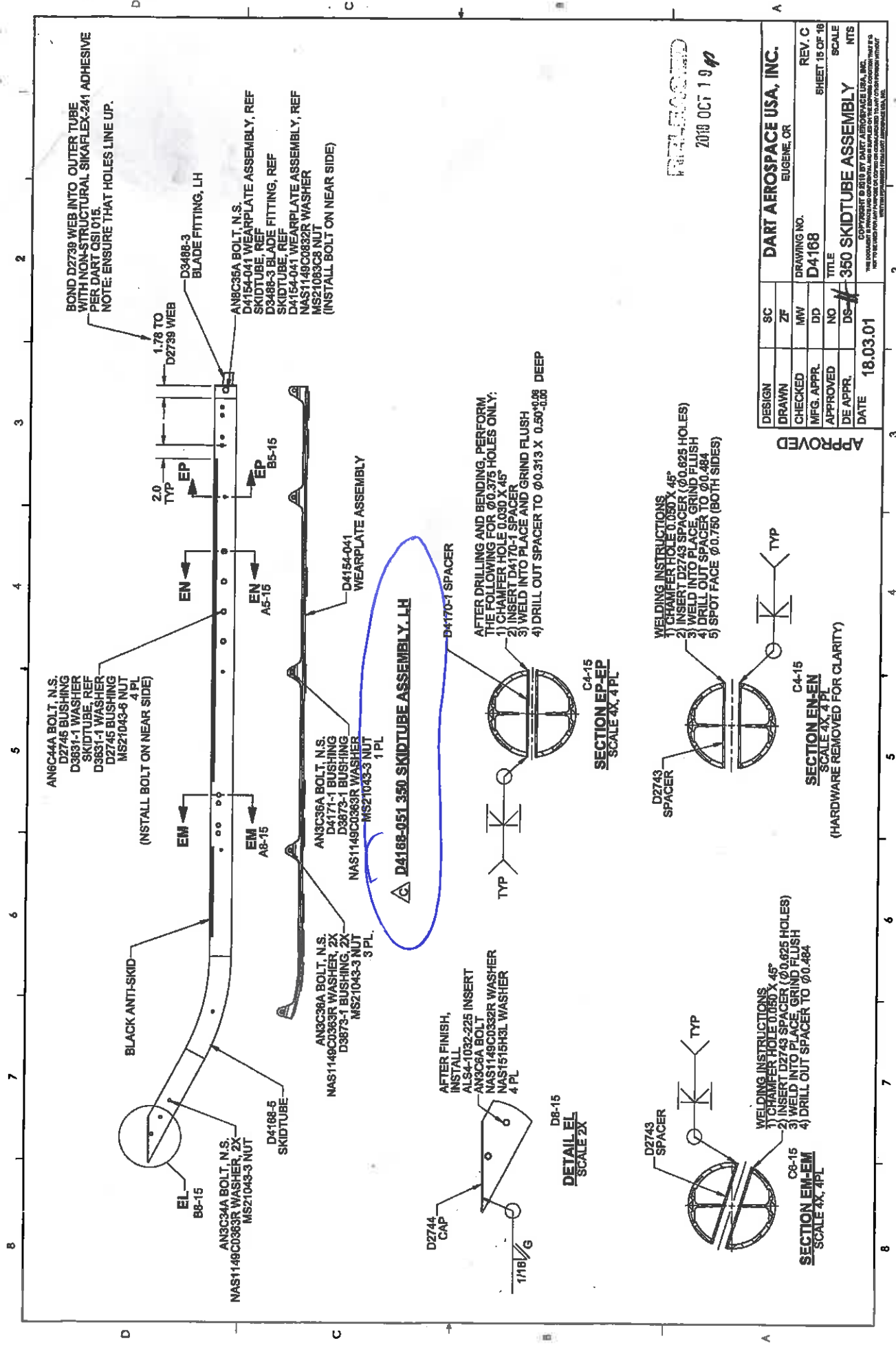
2013 OCT 19





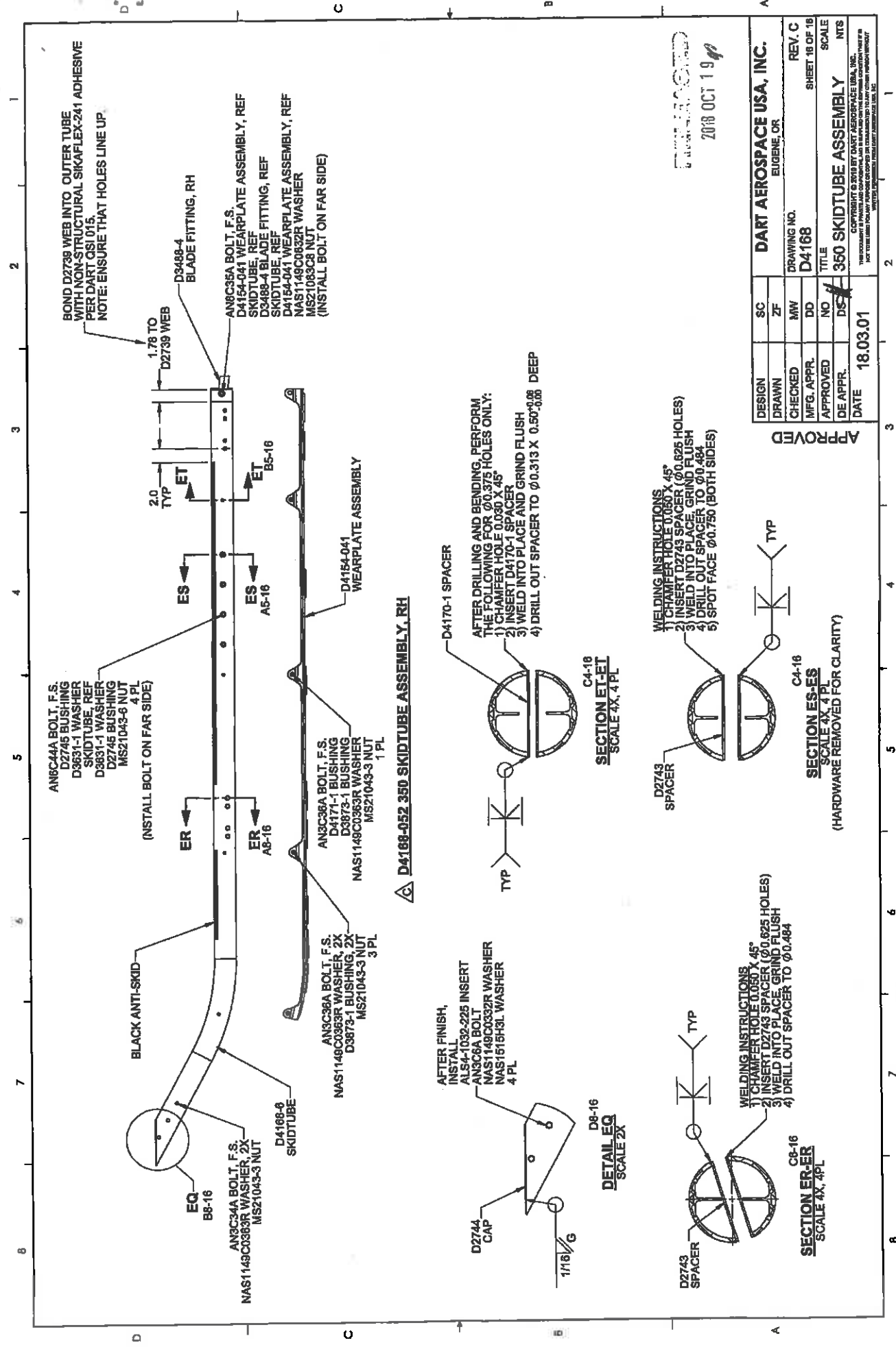






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DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR	REV. C
DRAWN	ZF		
CHECKED	MMV	DRAWING NO.	SHEET 15 OF 16
MFG. APPR.	DD	D4168	
APPROVED	NO	TITLE	SCALE
DE APPR.	DS-#	360 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01	EXPIRATION DATE: 18.03.01 EXPIRATION DATE: 18.03.01 THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. IT IS TO BE KEPT IN A SAFE PLACE AND NOT TO BE LOANED, REPRODUCED, COPIED, OR DISTRIBUTED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	



7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT
D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -019	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCUISEUR/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCUISEUR/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2745	BLADE
10	2	2	2	2	2	2		AN8C27A	BOLT
11	2	2	2	2	2	2		NAS1149CO832R	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

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Revision: K
Date: 18.04.04

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS

² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS

³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

Change Record

PAGE 1 OF 1

Part Number: D350-636-023/-024

Description: SKIDTUBE INSTALLATION LH/RH, STD COMPATIBLE W/TRAINING WEARPLATI

[illegible]